

Date: Tuesday, 4/4/2006 1:27:27 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : ANGLE
 Job Number : 26496
 Estimate Number : 10198
 P.O. Number : N/A Part Number : D21752
 This Issue : 4/4/2006 S.O. No. : N/A Drawing Number : D2175 REV. D
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : D
 Previous Run : 2628 Material : N/A
 Due Date : 4/28/2006 Qty: 20 Um: Each
 Written By : See comment below
 Checked & Approved By : 06.04.04
 Comment : Est E 04.06.09 Reformat KJ/RF

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M2024T3S063 2024-T3 .063 sheet



Comment: Qty.: 0.4958 sf(s)/Unit Total : 9.9162 sf(s)

Material: 2024-T3 (QQ-A-250/4) 0.063" thick

(M2024T3S.063)

Batch: M19059

ml 06/05/11

2.0 SHEAR SHEAR



Comment: SHEAR

Cut blank: 12.75" x 2.95" Grain along 2.95"

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA083 and Dwg D2175

Stack of 10

Identify as D2175-2

Prog Rev: D
 Dwg Rev: D

ml 06.05.11 (20)

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 06.05.11 (20)

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

06.05.13 (20)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: ANGLE

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Part Number: D21752

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr Stack

H.M 06/05/24

SAD 06/05/15

(20)

7.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE
Form as per Dwg D2175

SB 06/05/23

(20)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06/05/25

(20)

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

H.M 06/05/25

(20)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

06/05/25

(20)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: ~~Stock~~

06/05/25

(20)

12.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

06/05/26

(20)

Job Completion



06/05/26

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DART AEROSPACE LTD
HAMKESBURY, ONTARIO, CANADA

REV. D

SHEET 1 OF 1

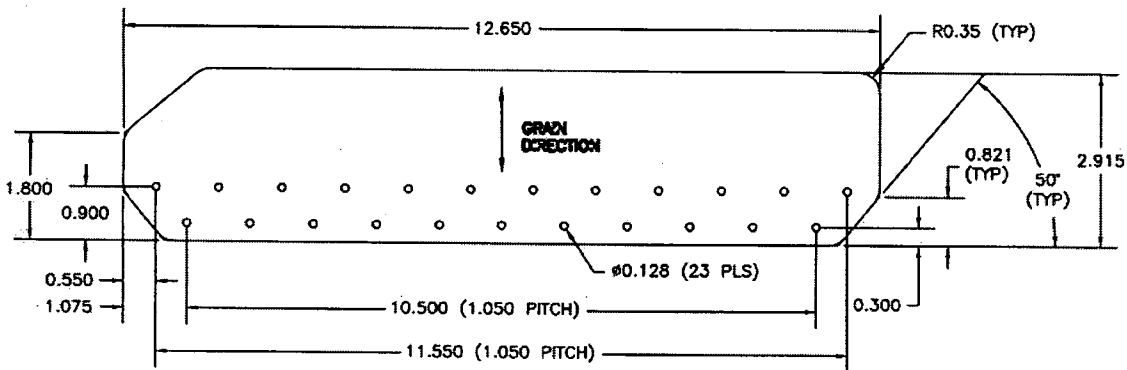
SCALE

1:3

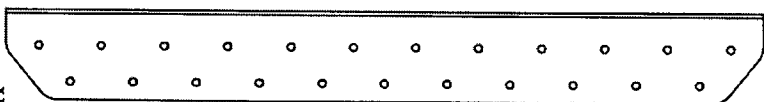
DESIGN	DRAWN BY	DRAWING NO.	TITLE
<i>FT</i>	<i>FT</i>	D2175	ANGLE
CHECKED <i>FT</i>	APPROVED <i>FT</i>		
DATE			
04.06.03			

RELEASED
04.06.03

A	95.10.25	NEW ISSUE
B	96.01.18	CHANGED DIMENSION
C	00.09.11	UPDATE FINISH SPEC
D	04.06.03	RE-DESIGN



D2175 FLAT PATTERN



**D2175-1 BEND DETAIL SHOWN
(D2175-2 BENT OPPOSITE)**

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) ALL DIMENSIONS ARE IN INCHES

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WITHOUT NOTICE



WORK ORDER
NO. 26496

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